

**Abstract**

In a process and an apparatus for making a plastic sleeve (56), plastic is fed into an extruder die (216). The plastic is extruded from the extruder die (216) as a molten plastic stream into a mold cavity (272) having an inner wall (270) with dimensions greater than the outside dimensions of the molten plastic stream. A first end (274) of the inner wall (270) includes a first projection (282) extending radially inward of the mold cavity (272) and circumferentially completely around the mold cavity (272). The molten plastic stream is vacuum expanded radially against the inner wall (270) and around the projection (282) to form a plastic sleeve (56) with a circumferential rib (74) and a aligned external first groove (92) at one end (60) of the sleeve (56).